

538

DART AEROSPACE LTD	Work Order:	24009
Description: Tube Detent Clip Base	Part Number:	D3440-9
Dwg: D3440 Rev. A page 4	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AL	05/08/12	20
2	MV	Cut blank: 1.250" x 1.250" x 1.825" long Material: 6061-T6 Bar 1.250" x 1.250" (M6061T6B1.250x01.250) Identify for D3440-9	Batch: M11972 BSG	05.08.22	20
3	MV	Machine as per Folio FA535 and Dwg D3440 Dwg Rev: <u>A</u> Identify as D3440-9	Folio Rev: <u>AA</u> BSG	05.08.28	20
4	QC2	Inspect parts as they come off the CNC machine	BSG	05.08.28	20
5	QC8	Second check	7ml	05/08/30	20
6	MV	Deburr	BSG	05.08.28	20
7	ST	Identify and Stock	CL	05/08/30	20
8	AC	Cost / part: <u>9.01</u>	545	05.08.31	20
9	DC	Close W/O <u>9.24</u> Inspect Level 21	DT	05/08/31	20

Rev	Date	Change	Revised By	Approved
A	05.06.30	New issue	KJ/JLM	

RELEASED
05.06.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

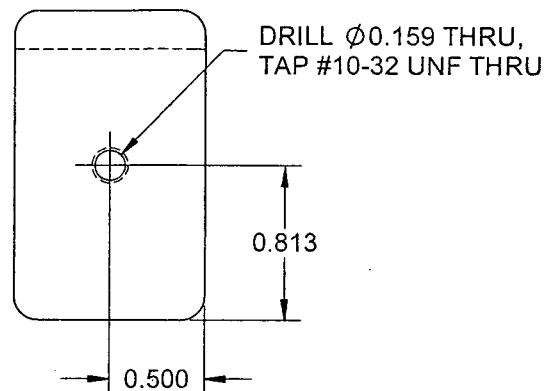
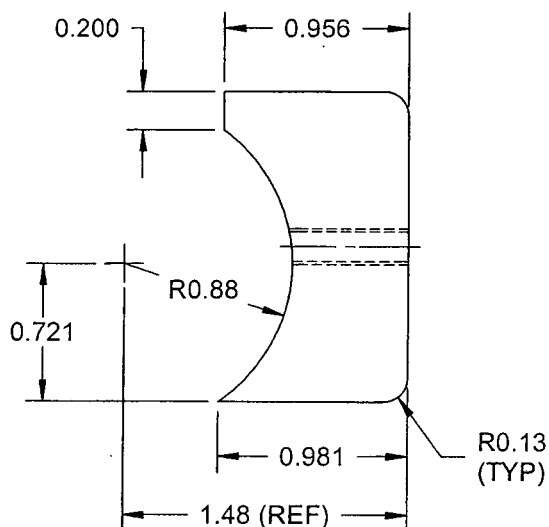
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05/08/31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



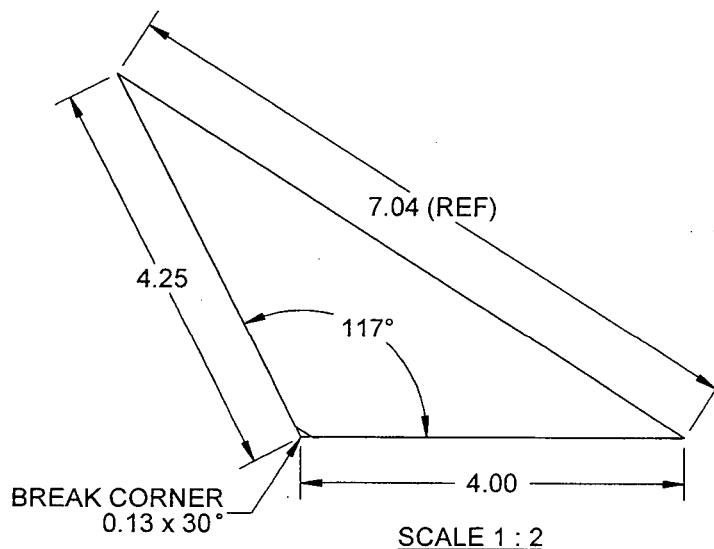
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3440	REV. A
DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SHEET 5 OF 7 SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/qq/a/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

RELEASED
[Signature]
05/08/13



SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24009

D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
11:26 am

Work Order No	: 0024009	Department Code:	
Project Name	: D3440-9	Burden Flags	: NNNNNNNN
Project For	: WK538	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3440-9	Invoice Number	:
Description	: Tube Detent Clip Base	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-09-05		
Est Finish Date	: 09-28-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

